

Date: Thursday, 2/14/2008 2:21:04 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 37452C		
Estimate Number	: 10356		
P.O. Number	:	Part Number	: D2279
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D2279 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 36710C	Material	:
Written By	:	Due Date	: 2/25/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>08 0214</u>		
Comment	: Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1544 sf(s)/Unit Total : 1.8522 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2279
 Batch: 100772 1882-20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D 2279
 Dwg Rev: D
 Prog Rev: D

18 8-2-20

(18)

2-Deburr if necessary 18 8-2-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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18 8-2-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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106 5-20

(18)
counted.

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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PTD

Comment: NC BRAKE
 Form As per Dwg D2279

513 08/03/24

(17)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2279 PAR #: NA Fault Category: Prod / Machines NCR: Yes No DQA: D Date: 28/04/04
 QA: N/C Closed: D Date: 06/04/04

NCR: <u>37452C</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>02/03/26</u>	<u>5</u>	<u>1 part was out of tolerance at the w-l-up</u>	<u>[Signature]</u> <u>QCFM</u>	<u>Scrap - destroy</u> <u>QTY (XL)</u>	<u>SB</u> <u>02/03/26</u>	<u>[Signature]</u> <u>02/03/27</u>	<u>[Signature]</u> <u>QCFM</u>	<u>[Signature]</u> <u>03/03/26</u>
		<u>R. Vennan error</u>						

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 37452C

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/27 X17

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/03/27 (17)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-27 (17)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Sylork

08/03/28 (17)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/02

Job Completion



08-03-28
U

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

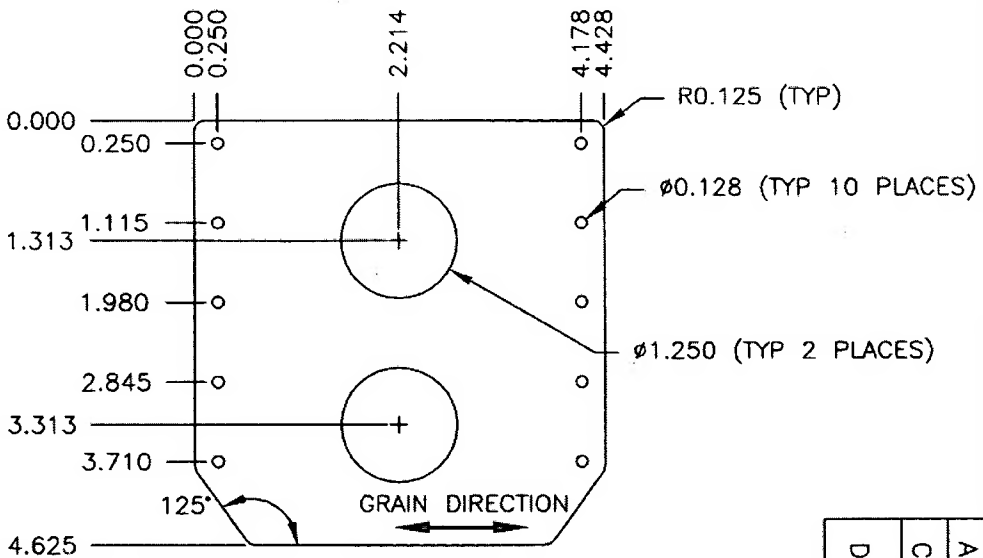
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

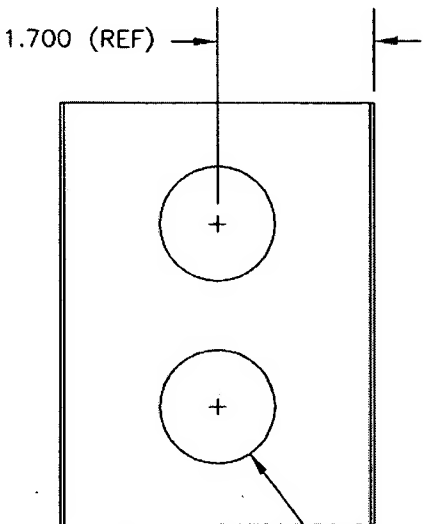
NOTE: Date & initial all entries



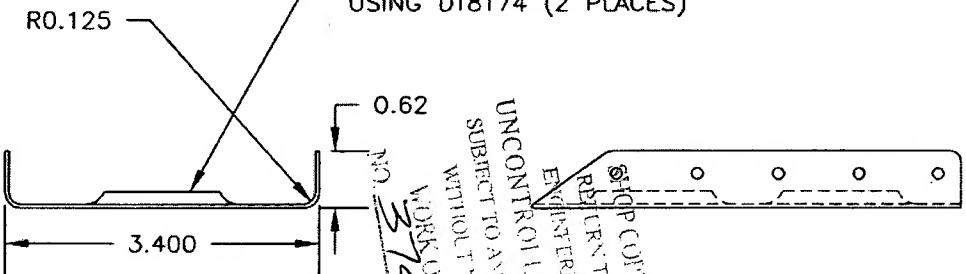
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
BW	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JP	DRAWING NO. D2279	SHEET 1 OF 1
DATE 98.10.05	TITLE STEP SPACER	SCALE 1:2	
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	



FLAT LAYOUT



FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
98.10.08 DS

UNDER REVIEW

OK 9/11/04
DESIGN OK, BUT CHECK WITH
TS BEFORE MANUFACTURE